

Date: Wednesday, 12/09/2007 1:42:30 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 31665
 Estimate Number : 12117
 P.O. Number : *N/A*
 This Issue : 12/09/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : 12/04/2007 Type : LARGE FAB ASSY
 Previous Run : 30168
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : est rev A 06.01.26 new issue EC

Drawing Name : LUG WELDMENT
 Part Number : D3353041
 Drawing Number : D3353 REV.A
 Project Number : N/A
 Drawing Revision : A
 Material : *N/A*
 Due Date : 22/04/2007

Qty: *(3)* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D335311 universal joint



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

✓ qty part number description batch
 1 D3353-11 universal joint *B31585*

P/L 07.09.19

(3)

2.0 D33535 back plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

✓ qty part number description batch
 1 D3353-5 back plate *B31587*

P/L 07.09.19

(3)

3.0 D335313 tubing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

✓ qty part number description batch
 1 D3353-13 tubing *B30454*

P/L 07.09.19

4.0 D335317 support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

pick:

✓ qty part number description batch
 1 D3353-17 support *B30176*

P/L 07.09.19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/09/2007 1:42:30 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 31665

Part Number: D3353041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 D33533 right plate



(3)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

pick:

✓
qty part number description
1 D3353-3 right plate

batch

B30457

Pl 07-09-19

6.0 D33539 STOP PLATE



(3)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

pick:

✓
qty part number description
1 D3353-9 stop plate

batch

B30459

Pl 07-09-19

7.0 D33531 left plate



(3)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

pick:

✓
qty part number description
1 D3353-1 left plate

batch

B30453

Pl 07-09-19

8.0 D33537 front plate



(3)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

pick:

✓
qty part number description
1 D3353-7 front plate

batch

B30178

Pl 07-09-19

9.0 D335315 lock bracket



(3)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

pick:

✓
qty part number description
1 D3353-15 lock bracket

batch

B30455 → 2

B30175 → 1

Pl 07-09-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 01/08/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/09/2007 1:42:30 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG WELDMENT

Job Number: 31665

Part Number: D3353041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(3)

Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3353

07-09-19

11.0

DO NOT USE

WELD INSPECTION



Comment: WELD INSPECTION

QC5 En 120114 (x3)
QC9

07/09/19 (3)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask part as per dwg D3353

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

m/8052

Feb 07/09/20

(3)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CAN 1

07/9/20 (3)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

07/09/21

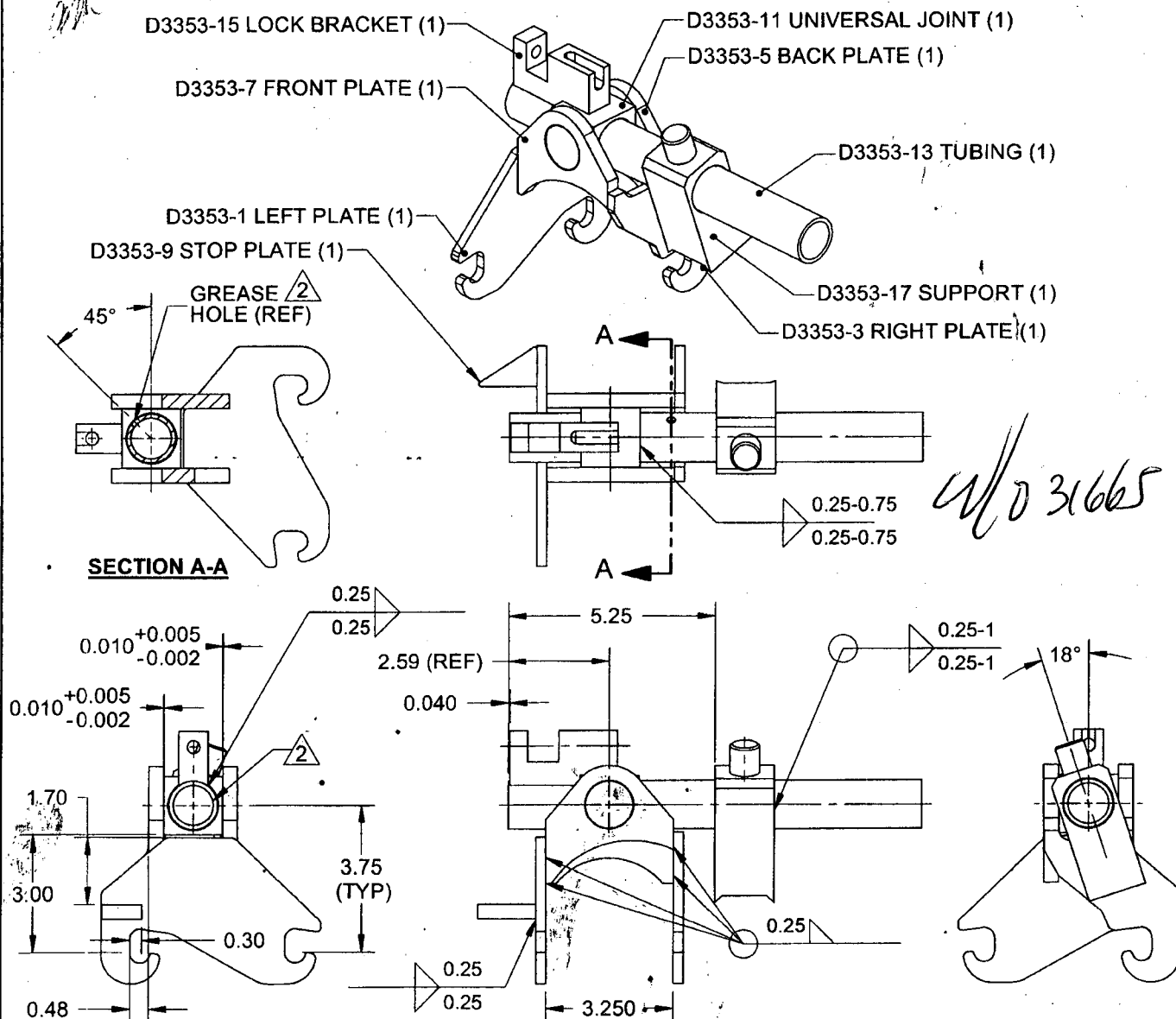
Job Completion



u 07-09-21

DART**RELEASED**
03/15/09

DESIGN REF	DRAWN BY REF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3353	REV: A SHEET 1 OF 10
DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:4
A	04.12.14	NEW ISSUE	

**D3353-041 LUG WELDMENT****NOTES:**

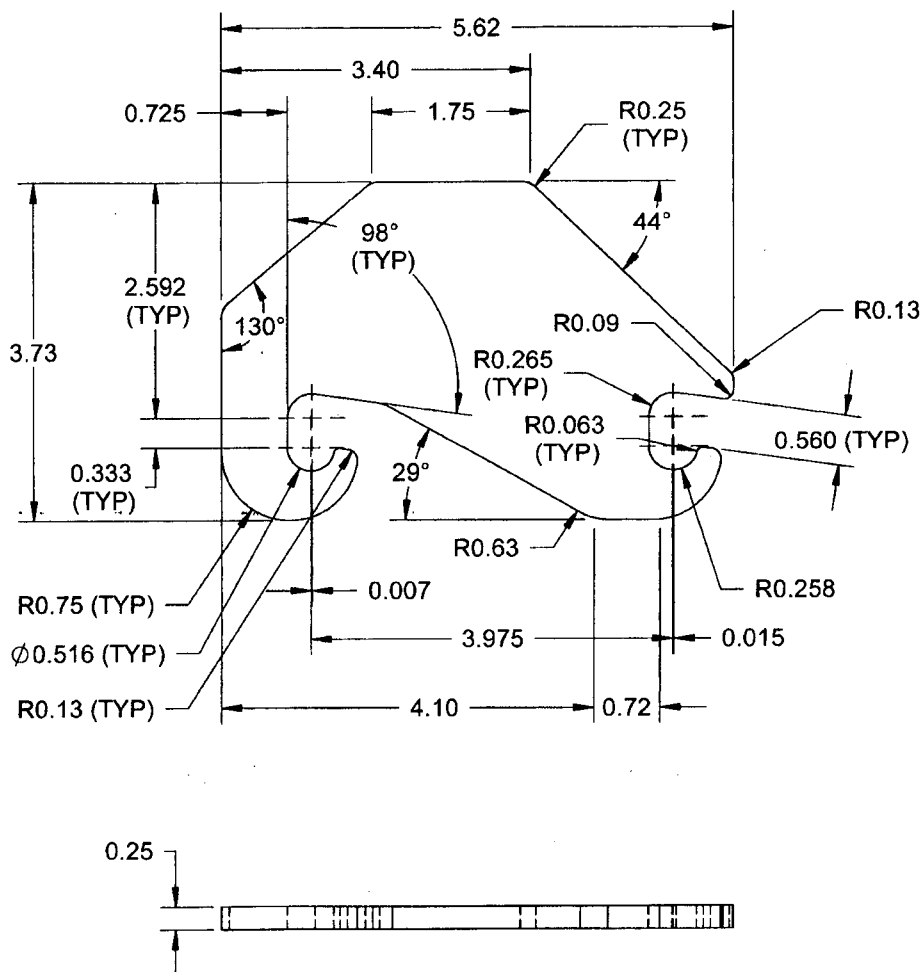
- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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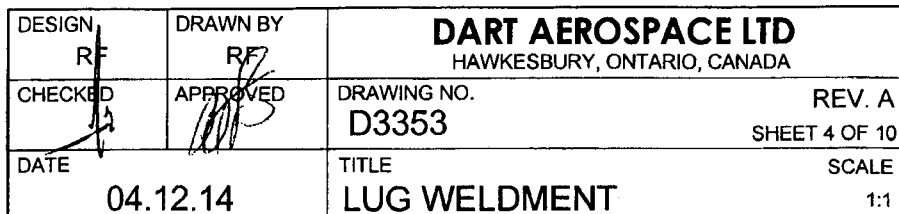
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3353	REV. A SHEET 3 OF 10
DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:2

RELEASED
[Signature]
01/07/14**D3353-1 LEFT PLATE****NOTES:**

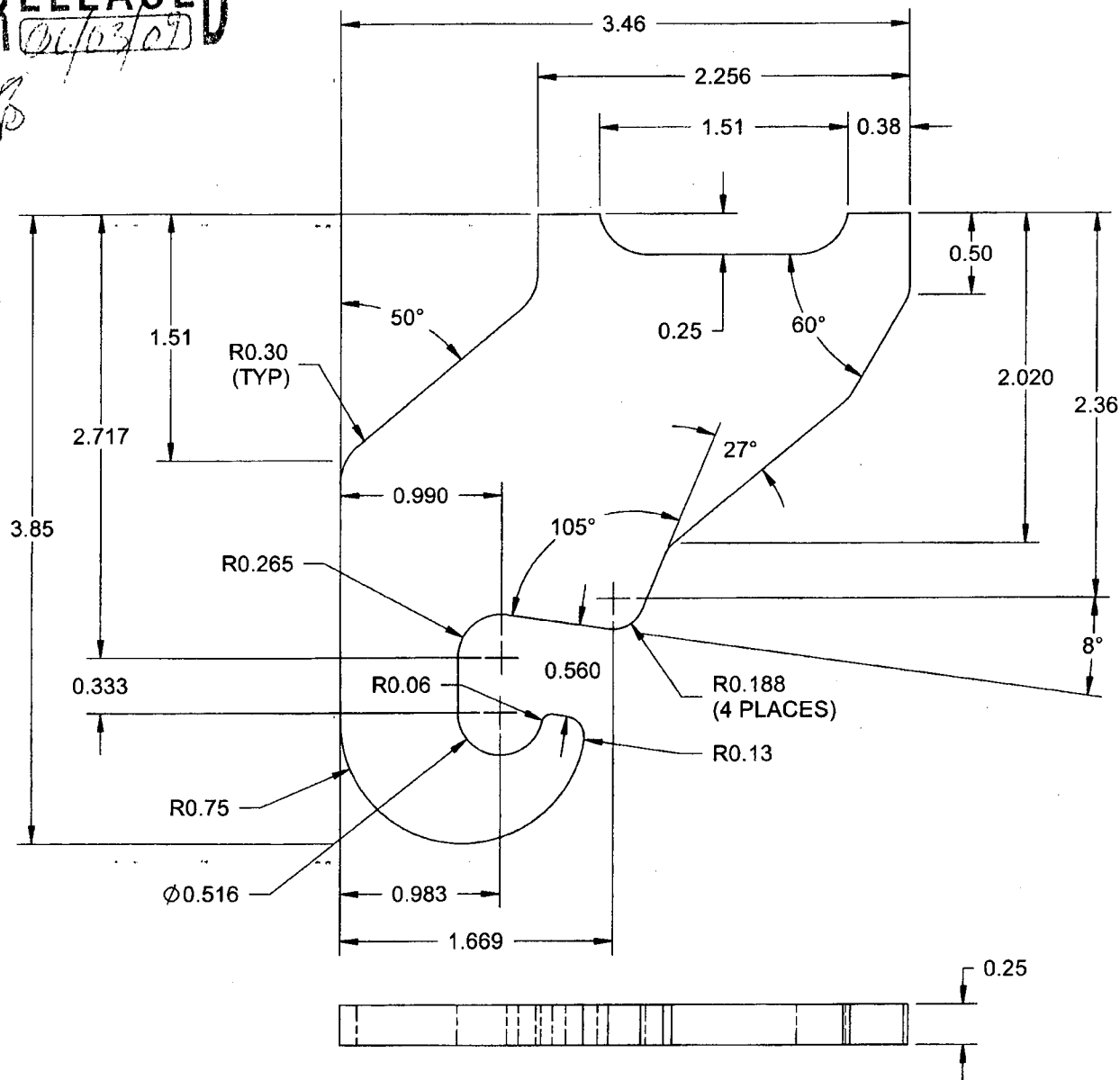
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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01/03/07





NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21,
38W/44W/50W/60W/70W SERIES STEEL 3 GAUGE (0.250 THICK)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

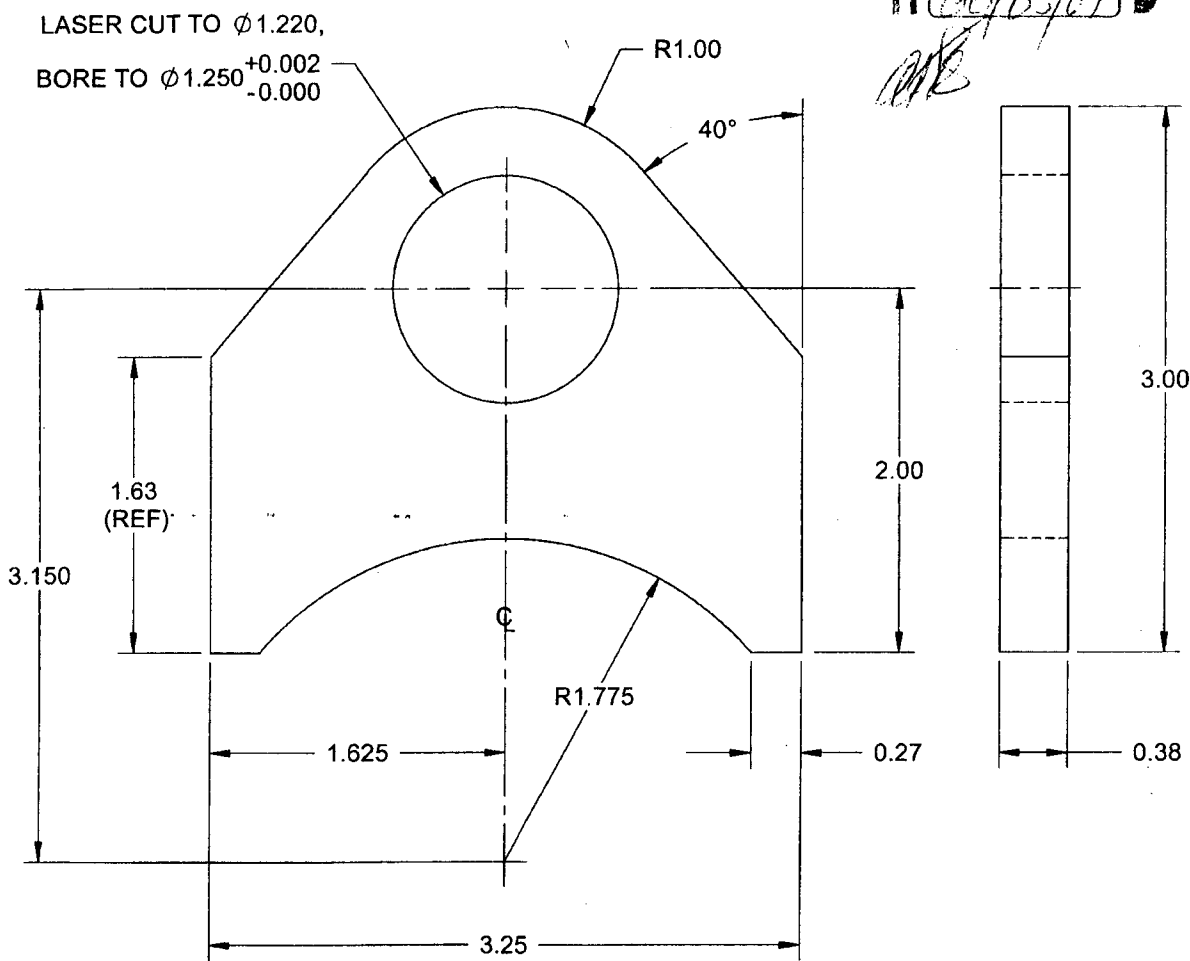
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
06/03/09
[Signature]



D3353-5 BACK PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

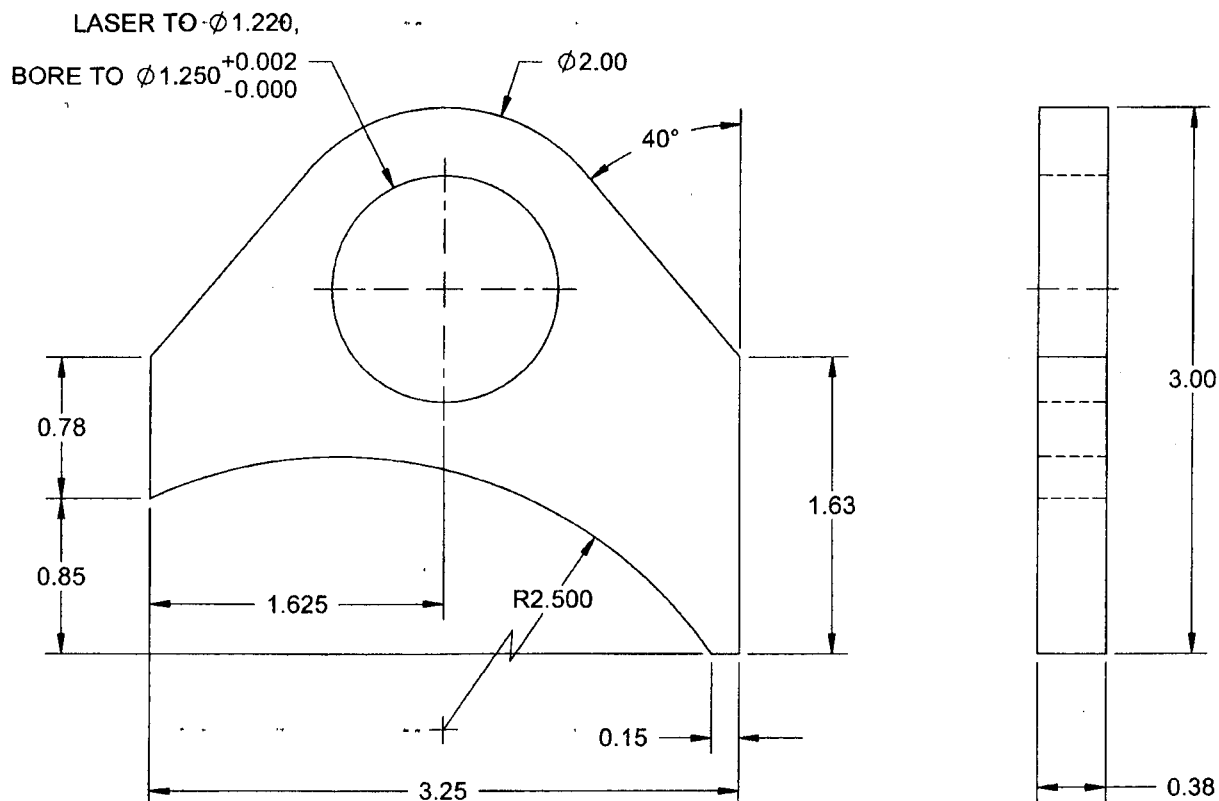
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
06/01/15



D3353-7 FRONT PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A108 OR CSA G40.21, 38W/44W/50W/60W/70W SERIES
STEEL 0.375 THICK PLATE
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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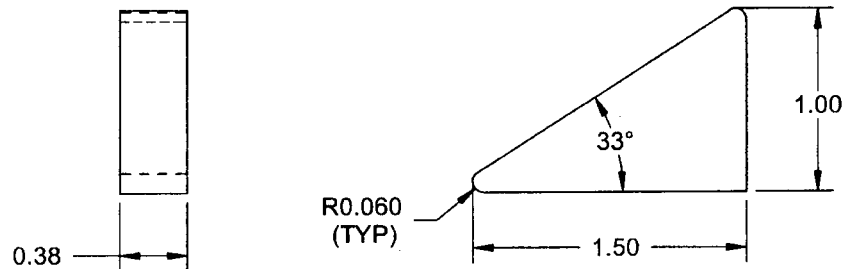
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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

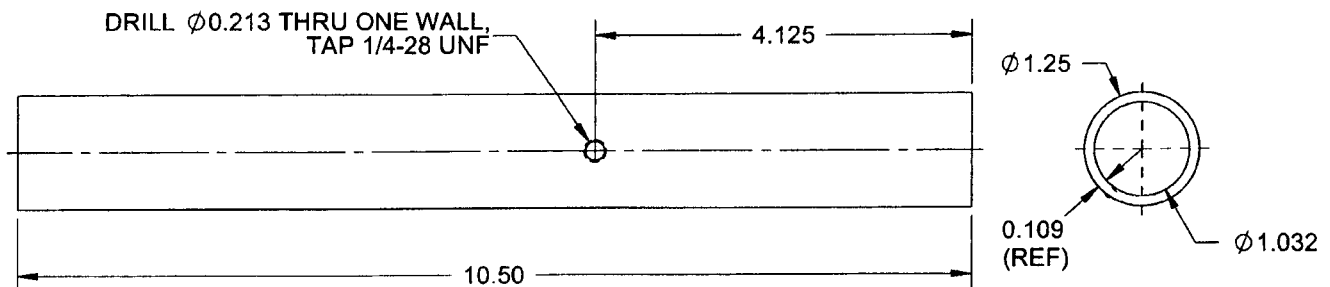
RELEASED
3/3/09

RF



D3353-9 STOP PLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR
CSA G40.21, 38W/44W/50W/60W/70W, 0.375 THICK
MILD STEEL BAR (REF. DART SPEC. M1010-B)



D3353-13 TUBING

NOTES:

- 1) MATERIAL: MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077,
Ø 1.250 x 0.125 WALL, COLD DRAWN STEEL TUBING
(REF. DART SPEC. M1020TR1.250W.109)

NOTES:

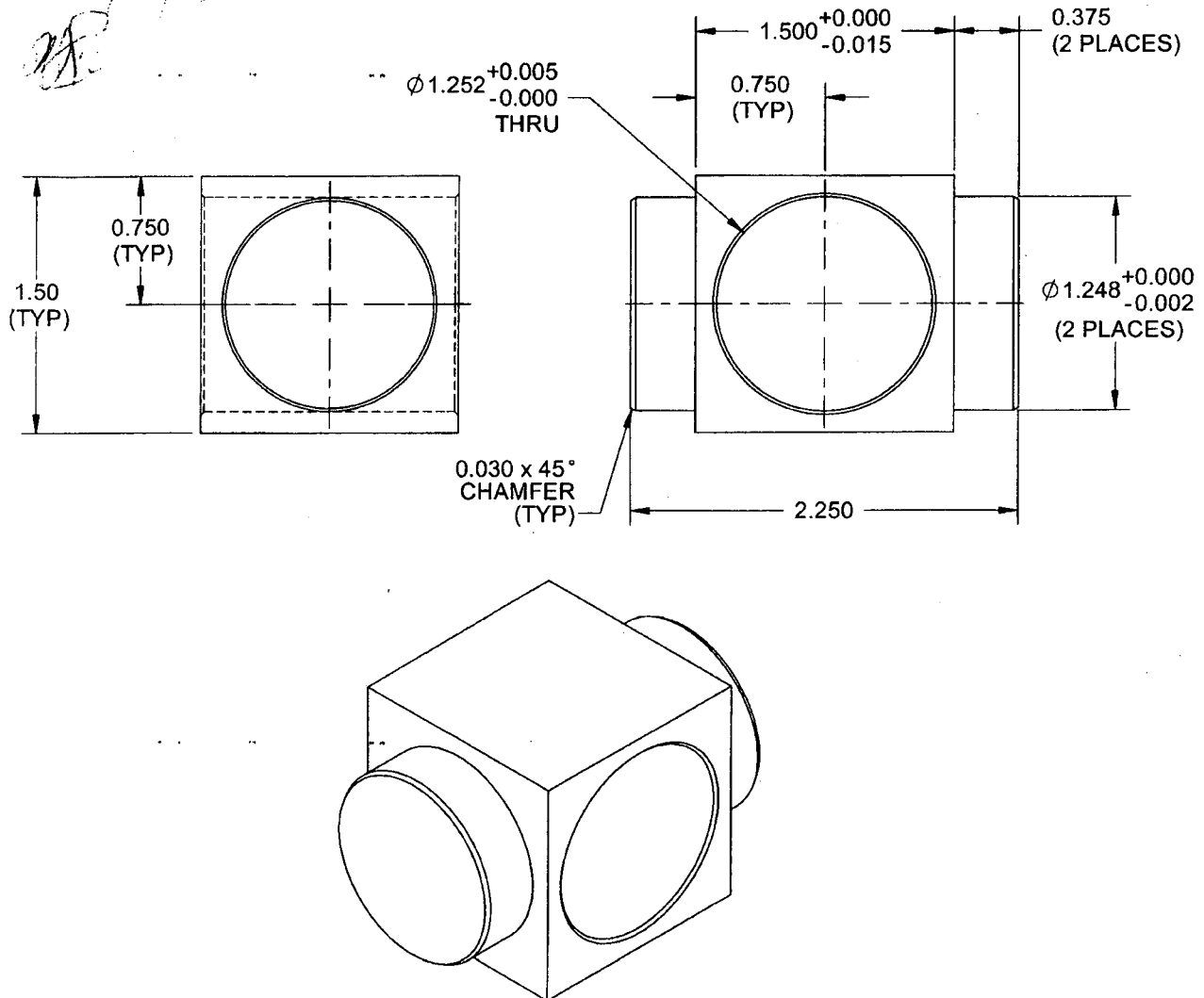
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DATE 04.12.14		TITLE LUG WELDMENT	SCALE 1:1

RELEASED
04/23/09**D3353-11 UNIVERSAL JOINT****NOTES:**

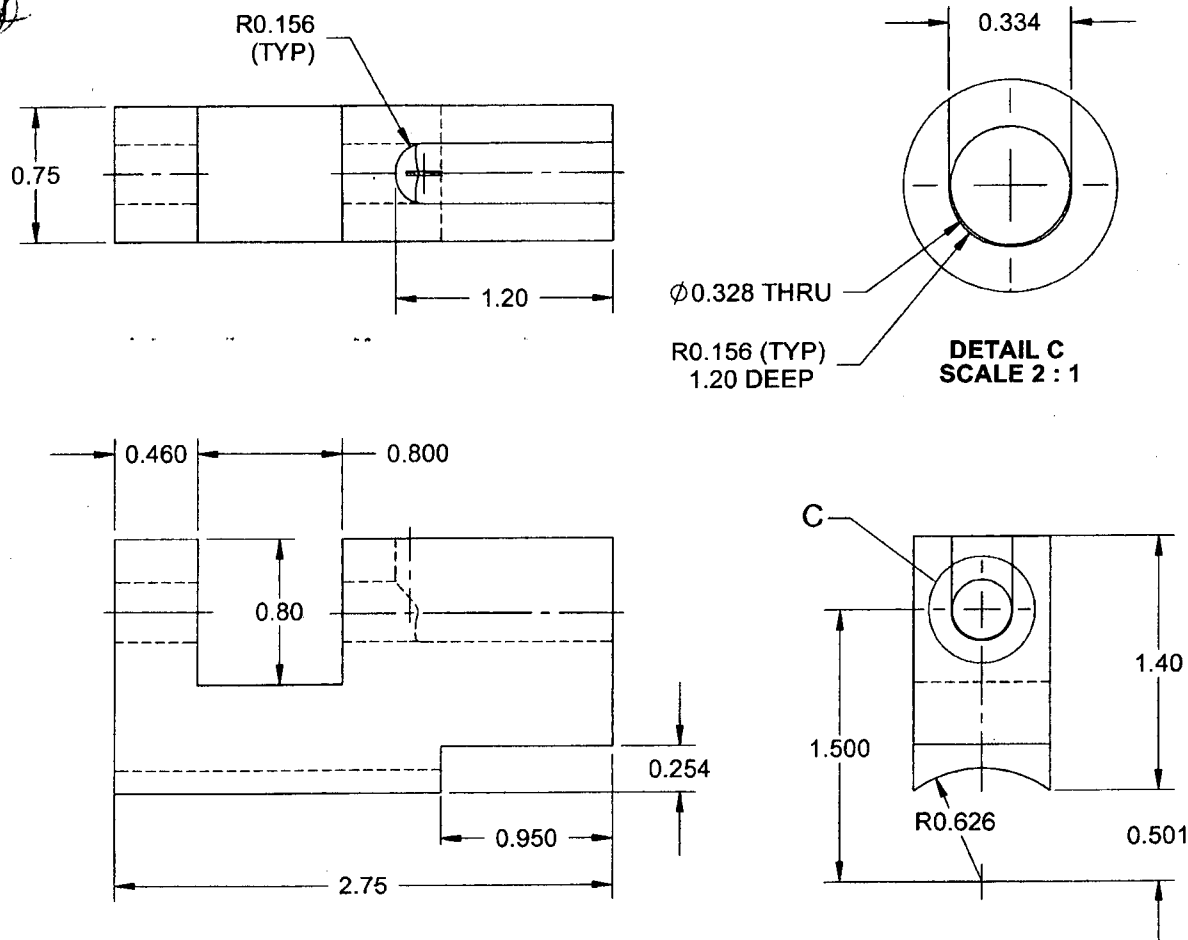
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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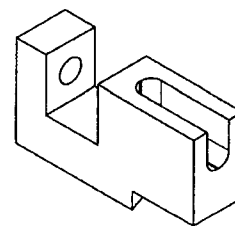
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DATE 04.12.14	TITLE LUG WELDMENT		SCALE 1:1

RELEASED
036/02/09**D3353-15 LOCK BRACKET****NOTES:**

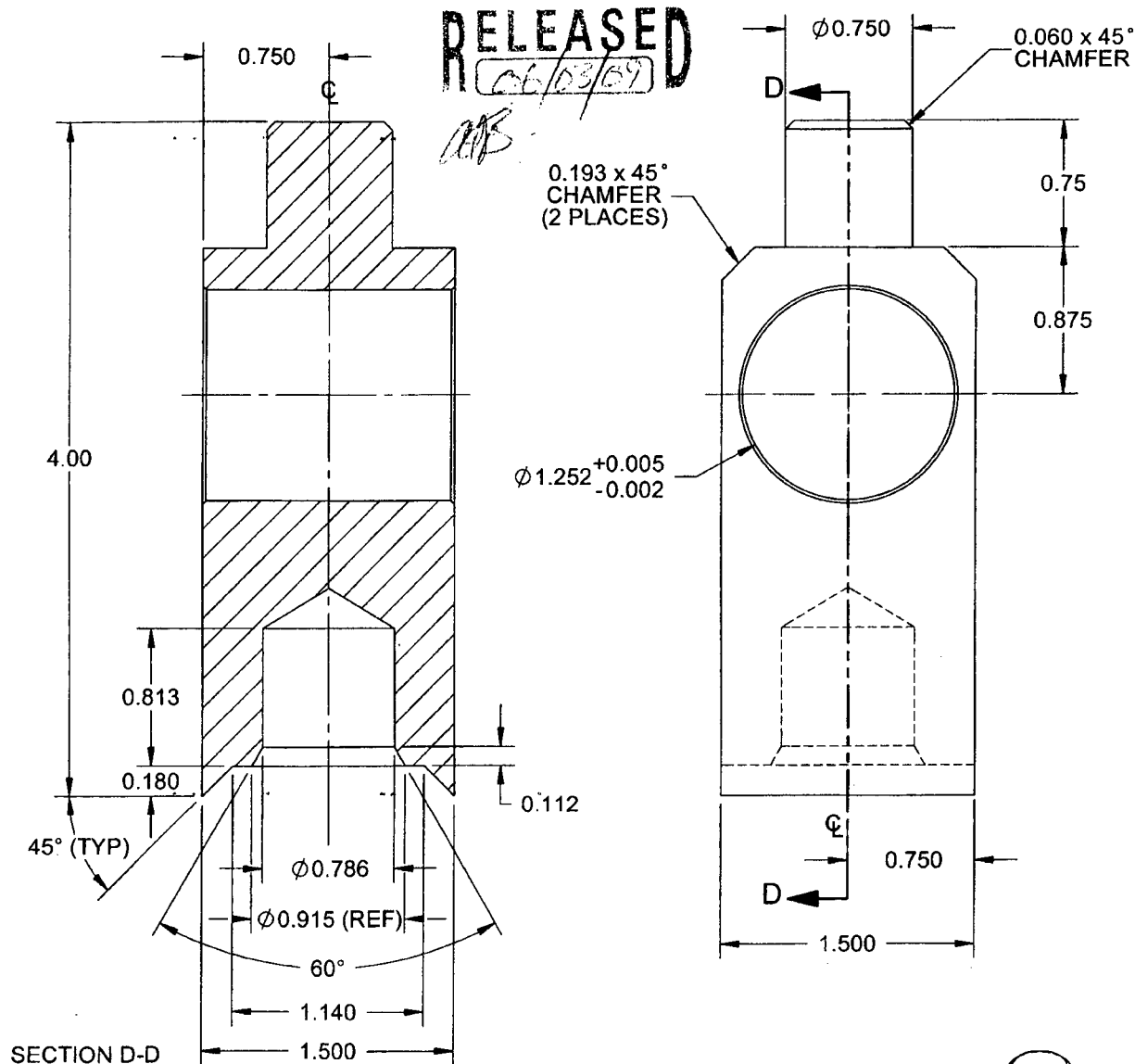
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**
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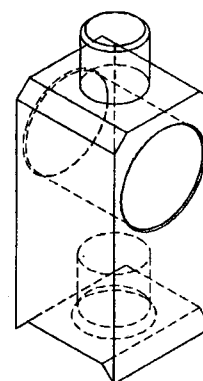
DESIGN RF	DRAWN BY RE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3353	REV. A
DATE 04.12.14		TITLE LUG WELDMENT	SHEET 10 OF 10 SCALE 1:1



D3353-17 SUPPORT

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.50 SQUARE MILD STEEL BAR (REF. DART SPEC. M1010-B1.500x01.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020



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